

Work Order ID 156194

Friday, January 27, 2017 12:46:56 PM

156194

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Item ID: D2010-104 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: ARM
Start Date: 1/19/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/27/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: **AS 21** Date: **JAN 30 2017** Poling: Date: Run Start ***NR1***
QC: **189** Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2010	Rev D								
100	NC BRAKE	0.00				4	Ø	17-2-7	DAS 19 9-89
100									
Brake NC	Memo	0.23							
Brake NC	Punch per Dwg. D2010-104 and Spec Control Dwg D2727 Identify as D2010-104								
110	Small Fab	0.00				4	Ø	17-2-7	DAS 19 9-89
110									
Small Fab	Memo	0.27							
Small Fab	1- Bend as per Dwg D2010 using bending Jig D2010-104T2 2- Deburr ends								
120	Small Fab	0.00				4	Ø	17-2-7	DAS 19 9-89
120									
Small Fab	Memo	0.14							
Small Fab	1- flare before installing plug as per dwg D2010 2- Install D2057 plug as per Dwg D2010								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
326 67 184								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER :									

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Page 2

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Start Date: 1/19/2017	Start Qty: 4.00	*4*	Cust Item ID:		
Required Date: 1/27/2017	Req'd Qty: 4.00	*4*	Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				<u>4</u>			68-6 88 FEB 13 2017
140 *140* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <u>M 136370</u> Memo START TIME: <u>8:20</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>8:50</u>	0.00 0.01							<u>H φ 17-02-24</u> 888
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<u>4</u>			DAS 38 9-89 FEB 24 2017

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>81351</u>	0.00							FEB 27 2017
	Memo	0.01							
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							<u>17/2/28</u>
	Memo	0.07							

DAS
21
9-89

FEB 28 2017

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Misidentified ☐	Past Due ☐																																																														

Picklist Print

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Parent Item: D2010-104

D2010-104

Parent Item Name: ARM

Start Date: 1/19/2017

Required Date: 1/27/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A04.02.17New issueKJ/JLM
IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC
IPP Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased			No	100	f	92.4116	1.5	6.31579			
M304TR0 500W 049									**			17-2-7	DAS 19 9-89
304 RD Tube .500 x .049W													

Location	Loc Qty	Loc Code
GA002	92.411573	
M127937	1.1741	
x1 M132872	8.271736	
M135325	8.651	
x3 M136569	74.314737	

D2057

Manufactured No

110 Each 6.0000 1 4

D2057

Plug

17-2-7

DAS 19 9-89

Location	Loc Qty	Loc Code
GA	6	
112928	1	
141007	5	

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
3440 67 13-04								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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